



Technical Service Bulletin

Adjusting 90-Line to Spray Viscosity

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Glasurit technical recommendations are designed to provide our customers with reliable information that will ensure a successful outcome regardless of application possibilities.

The standard 2:1 reduction recommendation for 90-line is a good, workable mix ratio that will result in an acceptable film, however, it may not always be an optimum reduction. The variety of equipment that is being used in shops as well as the individual expertise of each painter means that a more precise recommendation may be a better choice when reducing the basecoat. Reducing the basecoat to a viscosity range has real advantages to the painter as well as to the final finish.

Since the colors are created by mixing together various bases, and these bases have their own viscosity, each color will also have a viscosity that is unique. The amount of reducer that is needed to achieve optimum spray viscosity will vary from mixed color to mixed color. Please use the 2:1 reduction as a starting point. After measuring the viscosity if further reduction is called for, continue using the appropriate reducer until the desired viscosity is achieved.

The use of a DIN #4 dip cup is necessary in order to properly measure the viscosity of the basecoat prior to its application. While measuring the viscosity is an extra step, it does provide benefits. Basecoat at the proper viscosity will flash off more completely and quickly. This will result in a smooth, tight film that will be harder and more easily nibbed. This smooth film will also help the clearcoat become less textured when applied.

Reaching a viscosity within the recommended range can be achieved with an average amount of reducer. For example, after measuring viscosity on colors for a week, you may determine that you are adding between 75% and 85% reducer. You can elect to now reduce colors at 80% to eliminate measuring every job. However, because of temperature changes and other variables, occasionally checking viscosity is recommended.

The recommended spray viscosity for the Glasurit 90-Line basecoat colors is:

18-24 seconds when measured with a DIN #4 cup.

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